(54) ROLLING OF STEEL THICK PLATE
(11) 61-172603 (A) (43) 4.8.1986 (19) JP
(21) Appl. No. 60-14917 (22) 29.1.1985
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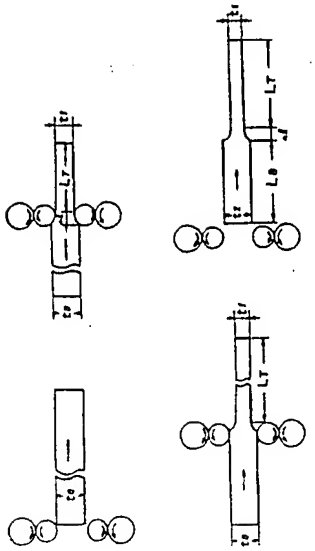
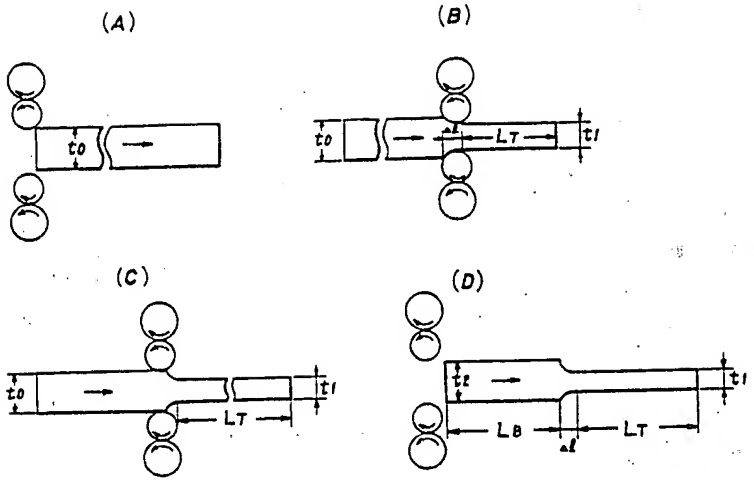
(51) Int. Cl⁴. B21B1/38

PURPOSE: To obtain a different-thickness rolling stock excellent in flatness and yield, by lowering the number of revolutions of rolls and controlling roll crowns in accordance with a load variation, at the time of changing a roll gap.

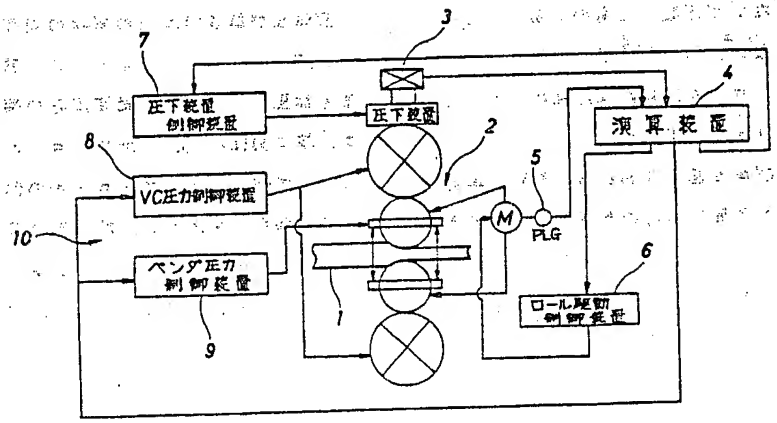
CONSTITUTION: A heated slab is rolled by a conventional method into a rolling stock 1 of plate thickness t_0. Next, a roll opening is set so as to obtain a plate thickness t_1, and the number of revolutions of roll is set to ordinary about 50~80rpm to roll the stock 1 from its front end into the length of LT. At that time, the number of revolutions of roll is lowered to ≦20rpm to perform low-speed rolling as well as the roll opening is enlarged so as to obtain the plate thickness of t_0 or t_2. That is, at the time of changing a roll opening; the number of revolutions of roll is lowered, and the roll crown is controlled in accordance with a load variation so that a thickness variation in the plate width direction is not produced, till the prescribed roll opening is obtained. After the prescribed roll opening is obtained, the number of revolutions of roll is returned to the ordinary ones to roll the stock as far as its rear end. In this way, a different-thickness rolling stock having a different-thickness part short in length, can be formed.



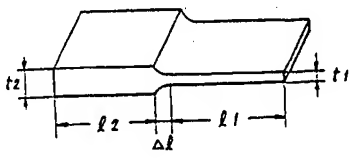
第１図


(A)
(B)
(C)
(D)
t0
t1
LT
t2
LB
Δℓ

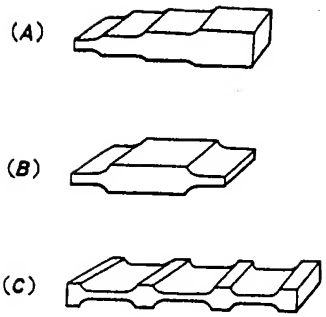
第２図


3
7
4
圧下装置制御装置
圧下装置
演算装置
8
2
5
VC圧力制御装置
M
PLG
10
6
ベンダ圧力制御装置
ロール屈曲制御装置
1
9

第３図


t2
t1
ℓ2
ℓ1
Δℓ

第４図



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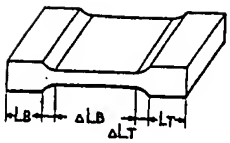

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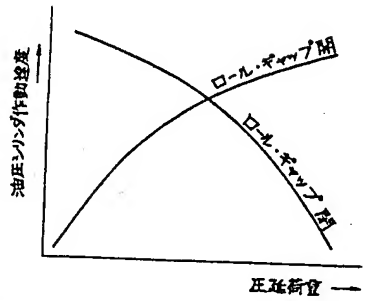

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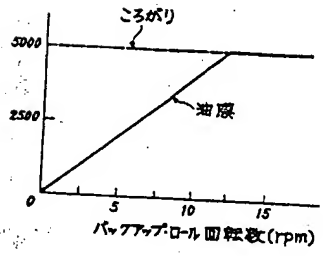

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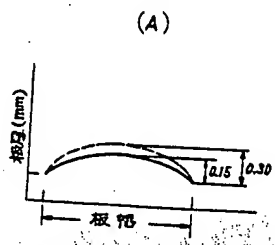

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